

Date: Monday, 05/11/2007 10:50:43 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 35481	
Estimate Number : 10901	
P.O. Number : <i>N/A</i>	Part Number : D33045
This Issue : 05/11/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3304 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>MA</i> Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 35481	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 19/11/2007 Qty: 6 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est A 04.09.07 New issue KJ/JLM Est Rev B now water jet 07-11-01 DD verified: EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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*.484*

Comment: Qty.: 0.0605 sf(s)/Unit Total : 0.3630 sf(s)

304/316 .040 Sheet

Batch: *105841**IB 07-11-6*

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3304

Dwg Rev: *B**IB 07-11-6*Prog Rev: *B**(8)*

2-Deburr if necessary

IB 07-11-6

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*IB 07-11-6***Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK*07/11/07**counter**(X8)*

5.0	BRAKE NC	NC BRAKE
-----	----------	----------

**Comment:** NC BRAKE

1-Deburr if necessary

2-Form as per Dwg D3304

IB 07/11/07 *(8)*
07/11/07 *(8)*

Date: Monday, 05/11/2007 10:50:43 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 35481

Part Number: D33045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 4/11/09 (x8)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

PD 07-11-19 (8)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

8 07/11/19

Job Completion



6 07/11/19

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 35481		
Estimate Number	: 10901		
P.O. Number	:	Part Number	: D33045
This Issue	: 10/31/2007 S.O. No. :	Drawing Number	: D3304 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	:	Material	:
Written By	: _____	Due Date	: 11/19/2007 Qty: 6 Um: Each
Checked & Approved By	: _____		
Comment	: Est A 04.09.07 New issue KJ/JLM		

Job Number:

Seq. #:	Machine Or Operation:	Description :
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2	1000	1000
3	1000	1000
4	1000	1000
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6	1000	1000
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99	1000	1000
100	1000	1000

1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: _____

Email or Ship DXF file to vendor

Laser Cut flat pattern per Dwg D3304

Possible Supplier: GFI & Industrial Laser

Material release note is required

2.0 D33045F Bracket

Comment: Qty.: 1.0000 U(s)/Unit Total : 6.0000 U(s)

Bracket

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0 QC6 DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK

5.0 BRAKE NC NC BRAKE

Comment: NC BRAKE

1-Deburr

2-Form as per Dwg D3304

3-Tumble

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/31/2007 3:26:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 35481

Part Number: D33045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF		DRAWN BY RF		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3304		REV. B SHEET 1 OF 4	
DATE 05.07.15		TITLE TUBE ASSEMBLY		SCALE 1:6	
A	04.08.18	NEW ISSUE			
B	05.07.15	UPDATE DIMENSIONS; ADD D3304-7/-8			



D3304-041 TUBE ASSEMBLY

UNCONTROLLED COPY

D3304-041/-043/-044 NOTES:

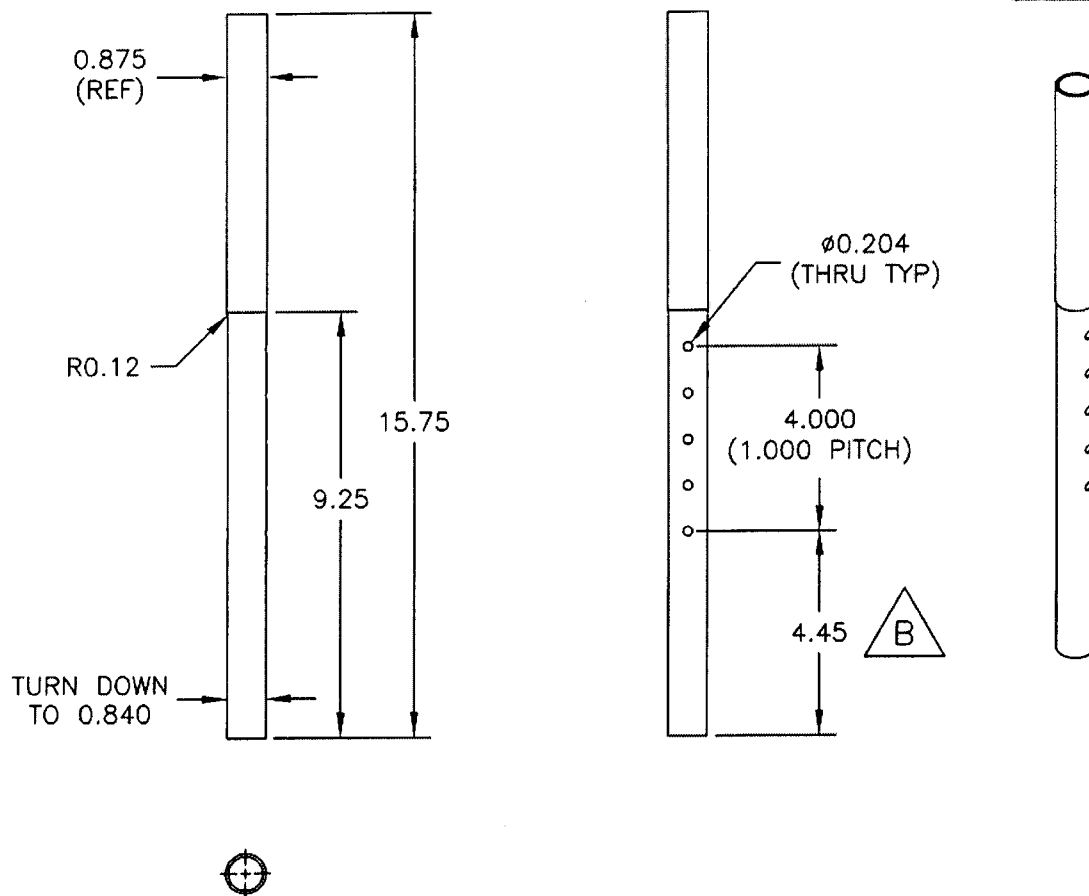
- 1) FINISH: POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER "TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"
- 7) IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

RELEASED
25-08-11



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. B SHEET 2 OF 4
DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4

RELEASED
05-08-11 *[Signature]*



D3304-1 TUBE

D3304-1 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL
(REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

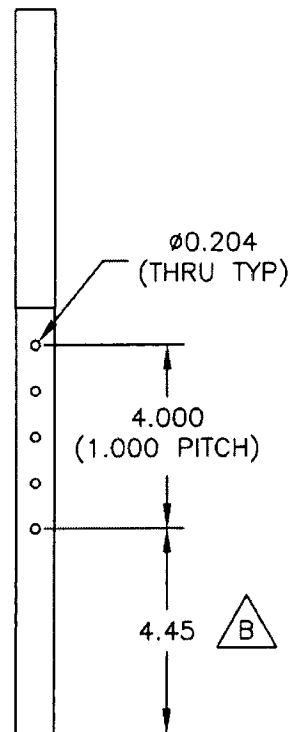
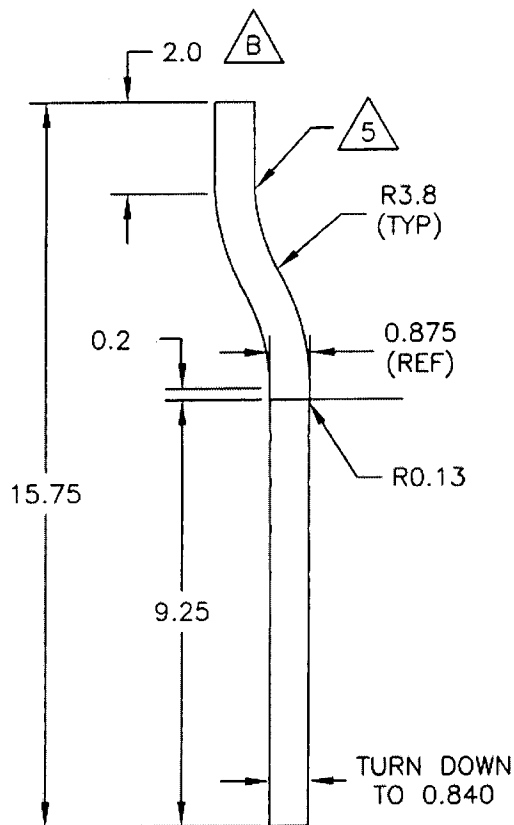
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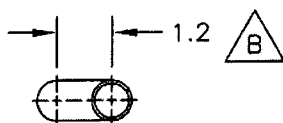
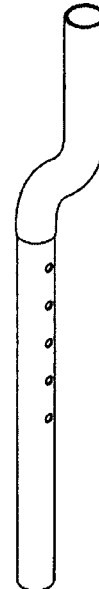
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. B SHEET 3 OF 4
DATE 05.07.15	TITLE TUBE ASSEMBLY		SCALE 1:4



RELEASED
05-08-11



D3304-3 TUBE

D3304-3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL (REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) BEND LINES 9.625, 13.375 DIMENSIONS

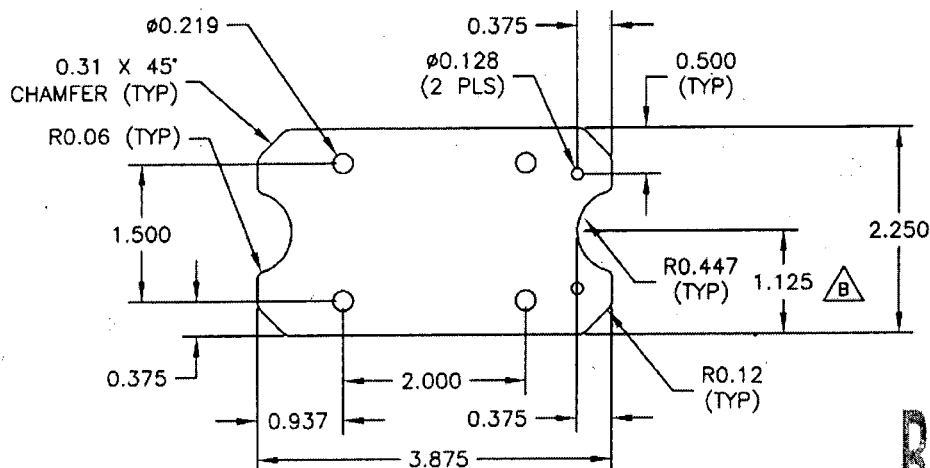
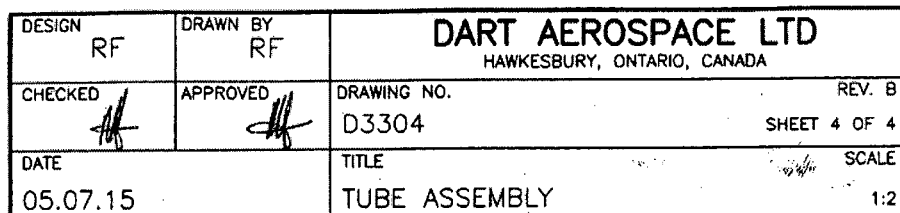
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NO. 35481

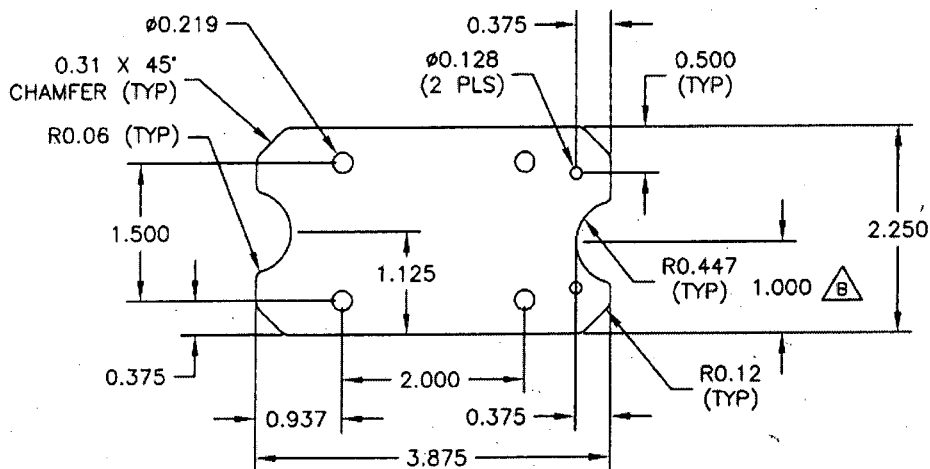
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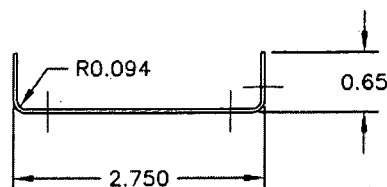


D3304-5 FLAT PATTERN

RELEASED
05-09-11



D3304-7/-8 FLAT PATTERN



D3304-5/-7 BRACKET
D3304-8 OPPOSITE

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SUBJECT TO AMENDMENT
GA) WITHOUT NOTICE
WORK ORDER
NO. 35481

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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